

Work Order ID 96270

Tuesday, January 22, 2013 8:41:52 AM

96270

ASAP

Page 1

Item ID: D4472-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Rib Assembly, LH

Start Date: 1/22/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/25/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 13-1-22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4472

REV B

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 17" LONG

AO

2

0

D4
33
89

13-01-22

13-02-07

110

0.00

110

Purchasing

Memo

0.00

Purchasing

ISSUE P/O: 18923
TO ARCHUR PRECISION(GLOBUS)
C OF C IS REQUIRED

cent

CA 13/01/25 (2)

13/4/15 (2)

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

DAS
13-1-19

13-2-19

3

Work Order ID 96270

Tuesday, January 22, 2013 8:41:52 AM

96270

Page 2

Item ID: D4472-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Rib Assembly, LH

Start Date: 1/22/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/25/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

150

Spray Painting per QSI005 4.2

0.00

150

SprayPaint

Memo

0.00

Spray Painting

PRIME TEMPO GREY

117319

13-02-19

2

2

2

0

0

DAS
05
13-02-19AS
13-2-19

Work Order ID 96270

Tuesday, January 22, 2013 8:41:52 AM

96270

Page 3

Item ID: D4472-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Rib Assembly, LH

Start Date: 1/22/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/25/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

2

DAS
05 13-02-20
9-83

180

0.00

180

Small Fab

Memo

0.00

Small Fab

install nutplates as per dwg

13-03-05

2

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

DAS
16 13/3/14
9-83

(42)

Work Order ID 96270

Tuesday, January 22, 2013 8:41:52 AM

96270

Page 4

Item ID: D4472-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Rib Assembly, LH

Start Date: 1/22/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/25/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location:

*Mod
T&D*

0.00

0.00

200

Packaging

Memo

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

0.00

210

QC

Memo

Quality Control

*13/3/18
MF
13-3-14*

Picklist Print

Tuesday, January 22, 2013 8:41:51 AM

Page 1

Work Order ID: 96270

Parent Item: D4472-041

Parent Item Name: Fwd Rib Assembly, LH

Start Date: 1/22/2013

Required Date: 1/25/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-12-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4472-1P		Purchased	No			110	Each	0.0000	1	2	96270		
----------	--	-----------	----	--	--	-----	------	--------	---	---	-------	--	--

M6061T6B0.750X08.000		Purchased	No				f	12.5000		2.84			
----------------------	--	-----------	----	--	--	--	---	---------	--	------	--	--	--

6061-T6 BAR .750" X 8.00"

M6061T6B0.750X12.000

M124443

Location

MAT051

Loc Qty

12.5

Loc Code

122321

12.5

M120866

Each

1,035.0000

MS21069L08

Purchased

No

ANCHOR NUT

Location

ST317

Loc Qty

1035

Loc Code

102587

35

123522

1000

180

Each

9,911.0000

6

12

MS20426AD3-5

Purchased

No

Rivet

Location

GA

Loc Qty

5715

Loc Code

4533

5715

ST333

4196

4444

4196

12

96270

13-03-05

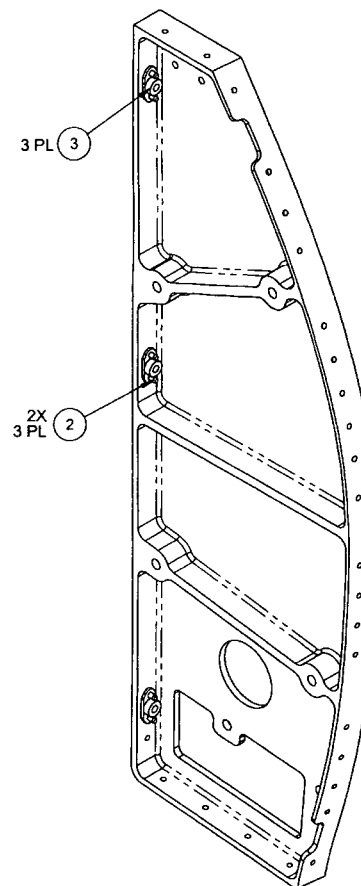
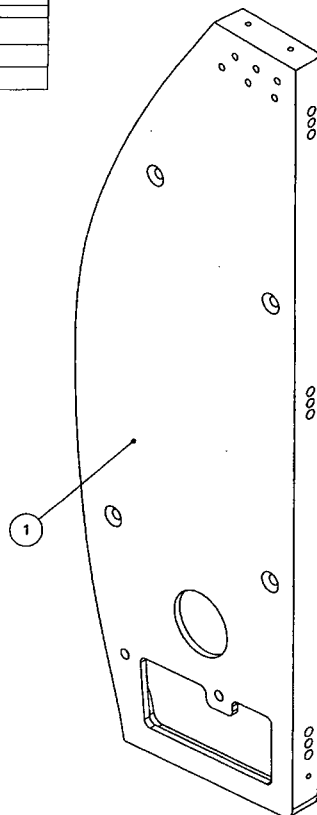
13-01-22

13-02-07

Mat'l system

13-03-05

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4472-041	FWD RIB ASSY (LH)
1	1	D4472-1	FWD RIB (LH)
2	6	MS20426AD3-5	RIVET, CSK
3	3	MS21069L08	NUTPLATE



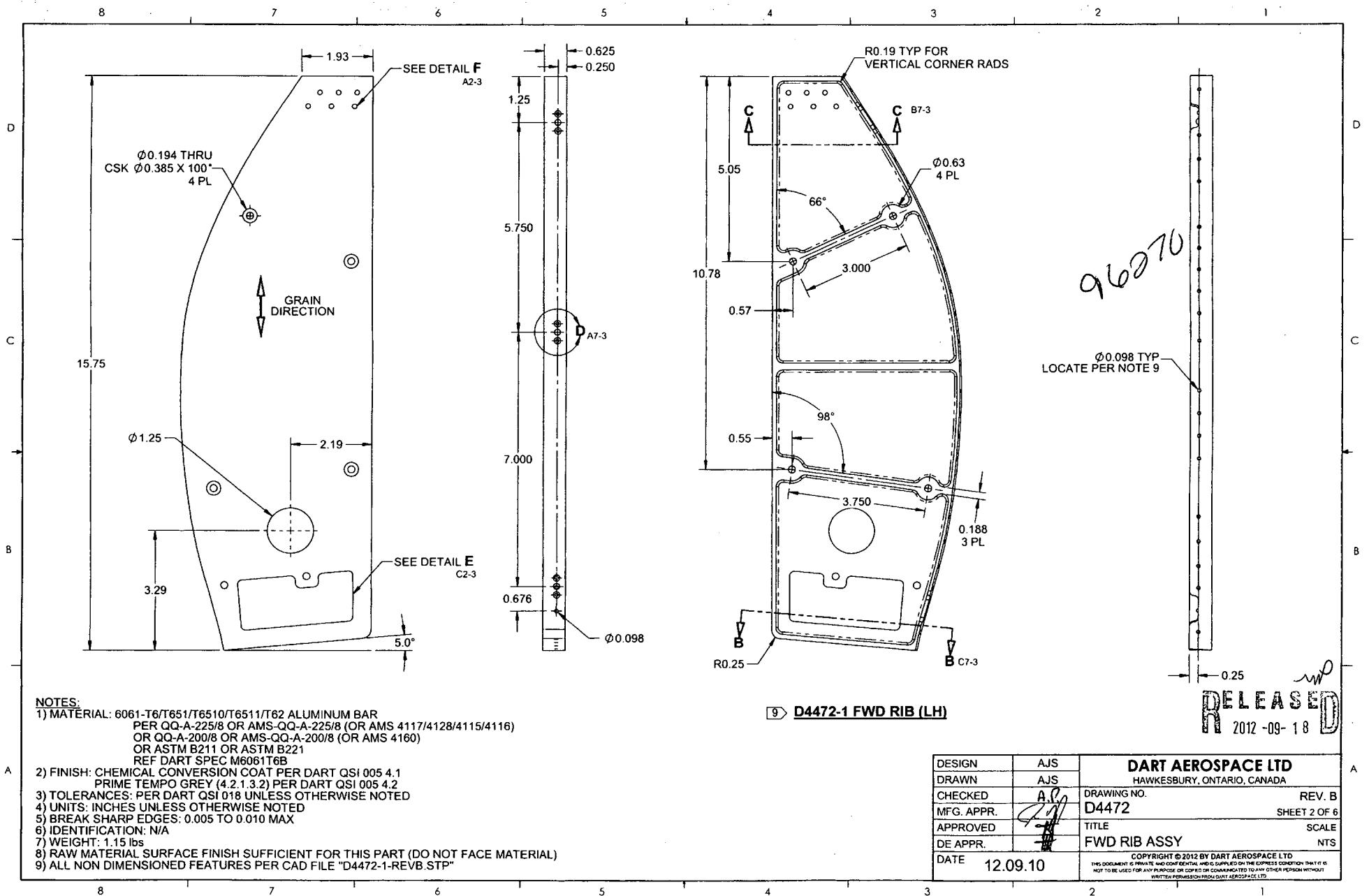
96270

D4472-041 FWD RIB ASSY (LH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.15 lbs




B	COMPLETE REDESIGN SEE REV A FOR DETAILS. ADDED 042 & -2 (RH CONFIGURATION). PRIMER NOTE ADDED.	AJS	12.09.10
A	NEW ISSUE	AJS	12.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>AJS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4472	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD RIB ASSY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

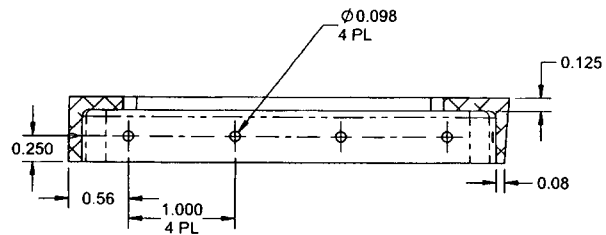


NOTES:

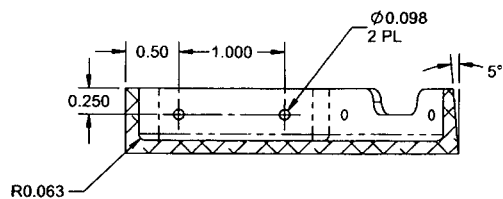
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.15 lbs
- 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART (DO NOT FACE MATERIAL)
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4472-1-REVB.STP"

9 D4472-1 FWD RIB (LH)

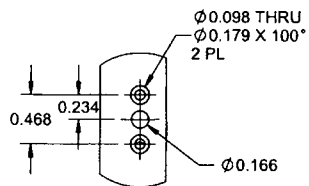
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4472	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		FWD RIB ASSY	NTS
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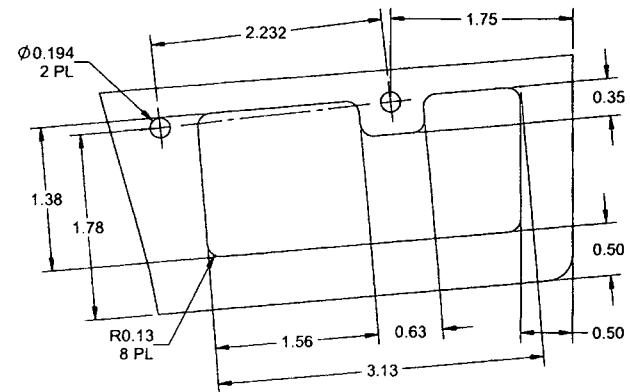
SECTION B-B 83-2
(SCALE 2X)



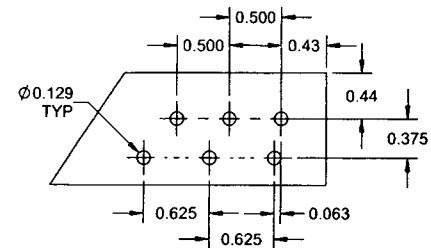
SECTION C-C D3-2
(SCALE 2X)






DETAIL D C5-3
NUTPLATE HOLE PATTERN 3 PL
(SCALE 2X)



DETAIL E B6-2
(SCALE 2X)



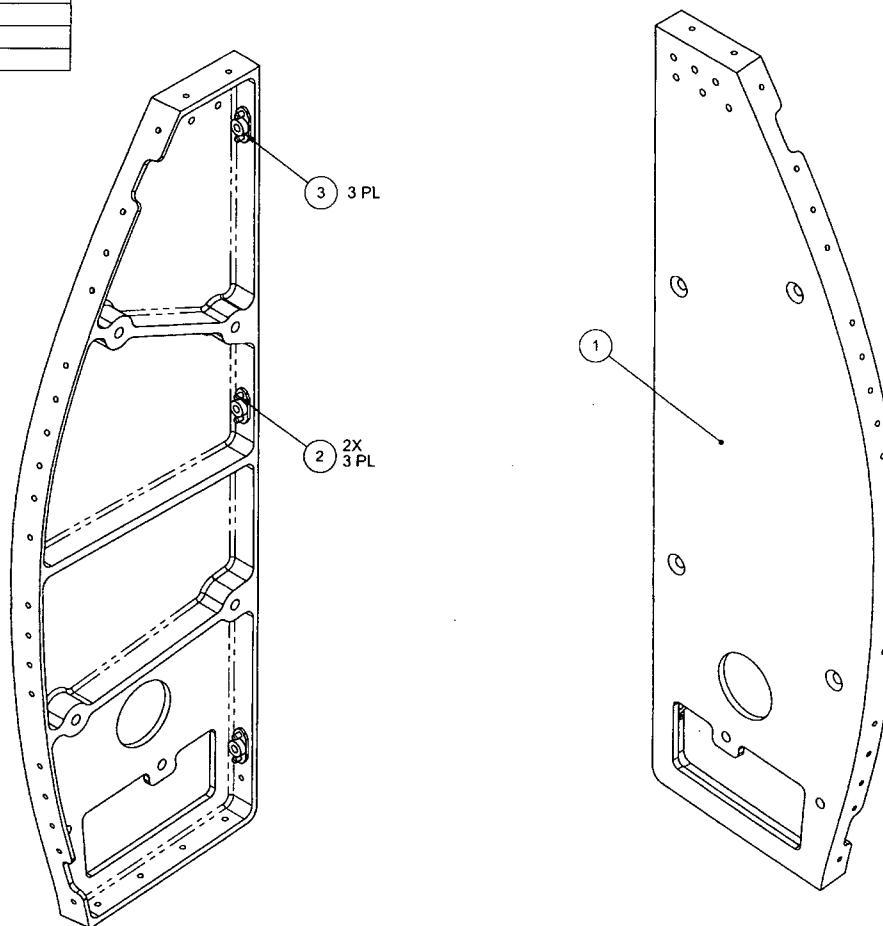
DETAIL F D6-2
(SCALE 2X)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AD	DRAWING NO.	REV. B
MFG. APPR.		D4472	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		FWD RIB ASSY	NTS
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96270

RELEASED
2012-09-26
MD

ITEM	QTY	P/N	DESCRIPTION
	X	D4472-042	FWD RIB ASSY (RH)
1	1	D4472-2	FWD RIB (RH)
2	6	MS20426AD3-5	RIVET, CSK
3	3	MS21069L08	NUTPLATE



96270

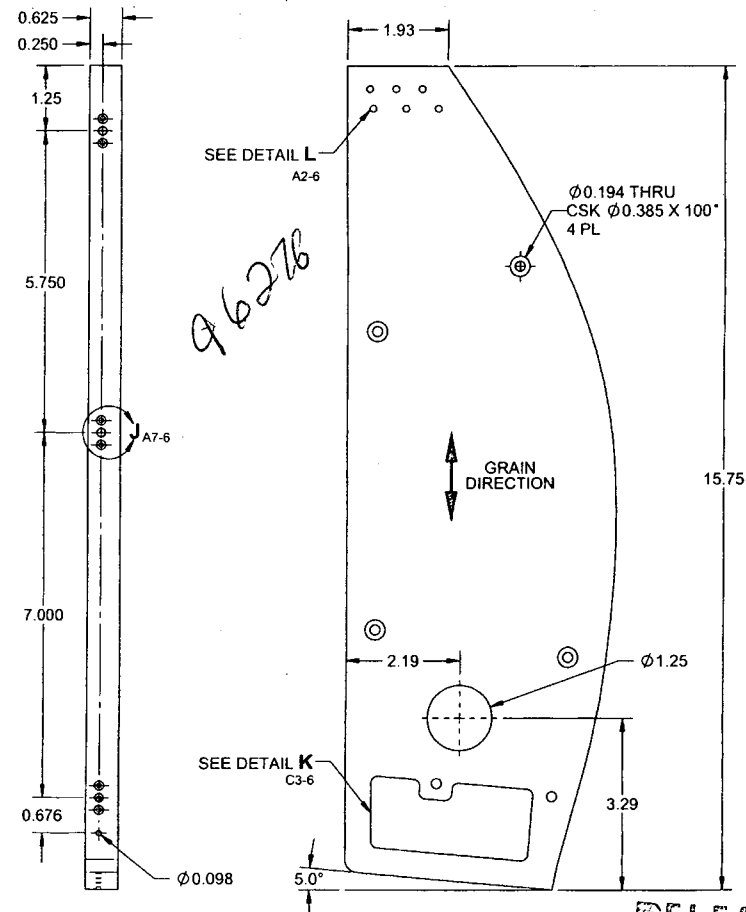
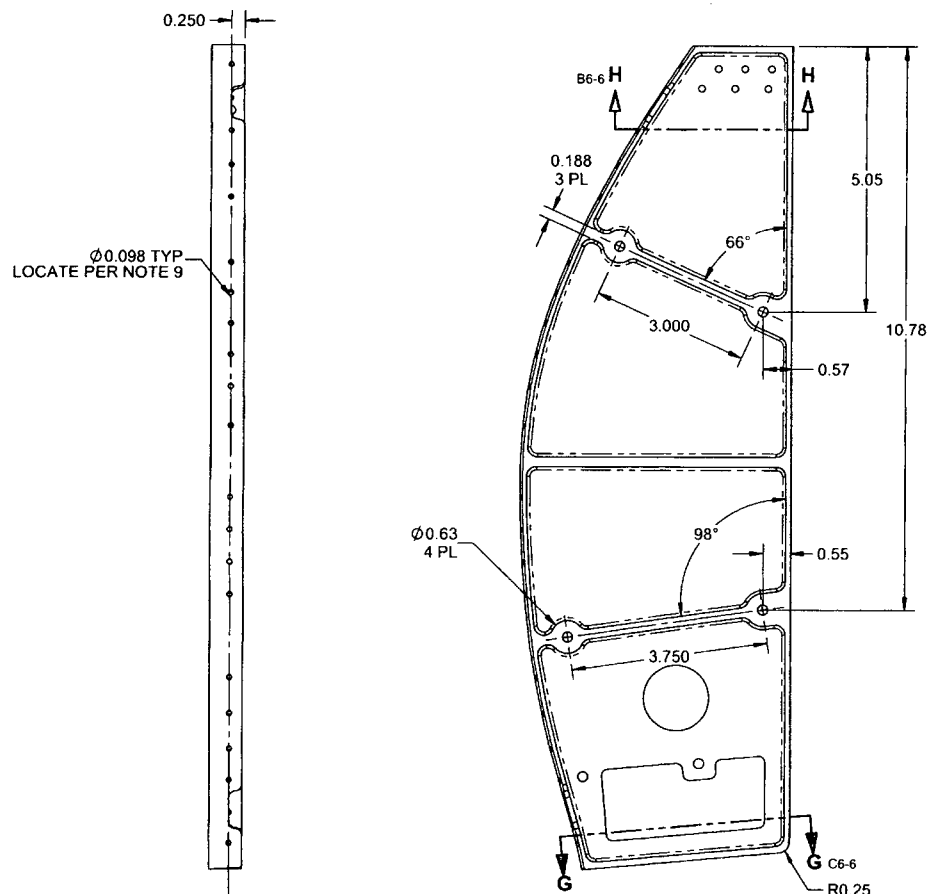
RELEASED
2012-09-18

D4472-042 FWD RIB ASSY (RH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.15 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4472	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		FWD RIB ASSY	NTS
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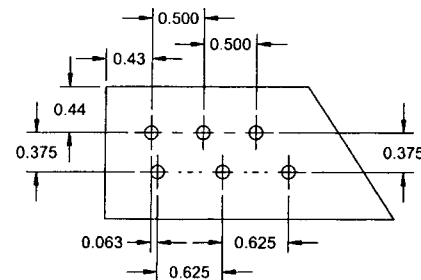
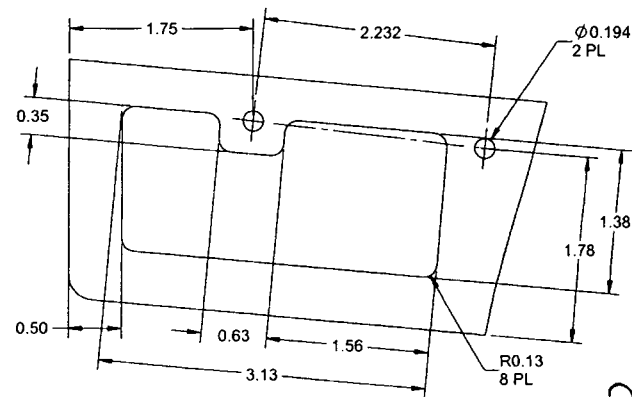
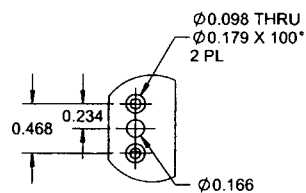
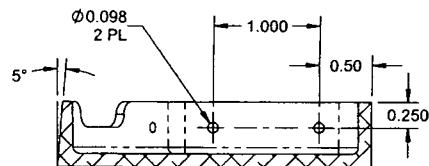
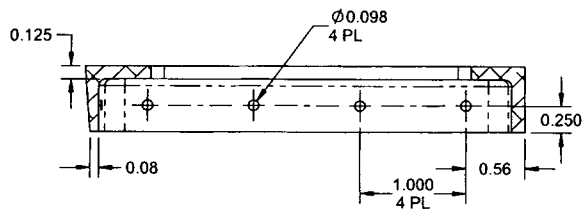
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.15 lbs
- 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART (DO NOT FACE MATERIAL)
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4472-2-REV.B.STP"

9 D4472-2 FWD RIB (RH)




RELEASE
2012-09-18

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.		D4472	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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96270

RELEASED
2012-09-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.		D4472	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		FWD RIB ASSY	NTS
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2228 Gladwin Cresent
Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
2/13/2013	388

Ship To

Main Finished Goods Location
Dart Aerospace
1270 Aberdeen Street
Hawksbury, Ontario
K6A 1K7

P.O. No.	Ship	Via	FOB	Project
18923	2/13/2013	delivered	Archer	

Qty	Item Code	Description
1	Sales	D4470-1P
2	Sales	D4472-1P
1	Sales	D4472-1P
2	Sales	D4501-1P
2	Sales	D4501-2P
		HST (ON) on sales



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
18923	D4470-1P	1
	D4472-1P	2
	D4472-1P	1
	D4501-1P	2
	D4501-2P	2

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 18923 issued by Dart Aerospace Inc.

Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3



Inspection Report

Customer Name Dart Aerospace			QTY 2	DWG # D4472-1		REV. B	Part Name FWD RIB ASSY (LH)			Date 14/FEB/13	Lot#	Job # 685-3
Page 1 of ____		Inspection Interval 100%		Special Notes								

Item #	DWG. Dim	Tolerance	Operator First Off	QA First		QA-Final		2	3	4	5	6	7	8	9	10
				A	R	A	R									
	Rev	B	✓	✓		✓										
	MAT	6061	✓	✓		✓										
	SUB	-														
	Deburr	YES	✓	✓		✓										
1	1.93	±.03	1.930	✓		✓		1.930								
2	Ø.194	+0.005/-0.001	.194	✓		✓		.194								
3	Ø.385	+0.006/-0.001	.387	✓		✓		.386								
4	100°	±1/2°	PP	✓		✓		PP								
5	4PL	-	✓	✓		✓		✓								
6	15.75	±.03	15.749	✓		✓		15.748								
7	Ø1.25	+0.012/-0.001	1.251	✓		✓		1.250								
8	3.29	±.03	PP	✓		✓		PP								
9	2.19	±.03	2.19	✓		✓		2.19								
10	.625	±.01	.625	✓		✓		.625								
11	1.25	±.03	1.251	✓		✓		1.25								
12	5.750	±.01	5.750	✓		✓		5.75								
13	7.000	±.01	7.000	✓		✓		7.000								
14	.676	±.01	.676	✓		✓		.676								
15	Ø.098	+0.004/-0.001	.098	✓		✓		.098								
16	R.25	±.01	PP	✓		✓		PP								
17	.55	±.03	.551	✓		✓		.55								
18	.57	±.03	.572	✓		✓		.571								
19	10.78	±.03	10.782	✓		✓		10.781								
20	5.05	±.03	5.052	✓		✓		5.051								
21	R.19	±.01	.190	✓		✓		PP								
22	Ø.63	+0.008/-0.001	.626	✓		✓		.625								

24	66°	±1/2°	DP	/	/	PP
25	3.000	±.01	3.001	/	/	3.000
26	98°	±1/2°	PP	/	/	PP
27	3.750	±.01	PP	/	/	PP
28	.188	±.01	.188	/	/	.188
29	3PL	-	✓	/	/	✓
30	Ø.098	+0.004/-0.001	.098	/	/	.098
31	.25	±.03	.249	/	/	.250
32	.25	±.03	.249	/	/	.250
33	.56	±.03	.560	/	/	.560
34	1.000	±.01	PP	/	/	PP
35	4PL	-	✓	/	/	✓
36	Ø.098	+0.004/-0.001	.098	/	/	.098
37	4PL	-	✓	/	/	✓
38	.125	±.01	.128	/	/	.127
39	.08	±.03	.081	/	/	.080
40	Ø.098	+0.004/-0.001	.098	/	/	.098
41	5°	±1/2°	PP	/	/	PP
42	1.000	±.01	PP	/	/	PP
43	.50	±.03	.500	/	/	.501
44	.250	±.01	.249	/	/	.250
45	R.063	±.01	PP	/	/	PP
46	Ø.098	+0.004/-0.001	.098	/	/	.098
47	Ø.179	+0.005/-0.001	.179	/	/	.181
48	100°	±1/2°	PP	/	/	PP
49	2PL	-	✓	/	/	✓
50	Ø.166	+0.005/-0.001	.166	/	/	.166
51	.234	±.01	PP	/	/	PP
52	.468	±.01	PP	/	/	PP
53	Ø.194	+0.005/-0.001	.194	/	/	.1945
54	2PL	-	✓	/	/	✓
55	2.232	±.01	2.232	/	/	2.233
56	1.75	±.03	PP	/	/	PP
57	.35	±.03	.348	/	/	.348

